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D044-715-011
Job Sheet 187767



7262

Part No: D044-715-011

Job Qty: 2 pcs

Part Name: R44 Cargo Mirror



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/17/18

Job Tracking No:

Due Date: 1/7/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3243 REV A, IIN-D044-715 REV A IPP Rev:A 04.02.18 New issue KJ/JLM IPP Rev:B 06-04-28
Manufactured on Water Jet JLM IPP Rev:C 08-06-10 as per ECN1195p DD verified by:EC IPP Rev:D 11.05.04
remove FE-032-EF DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	2 pcs	1/7/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		



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Container No: S141088



Part: D044-715-011

Job No: 187767

Serial No/Batch: S141088

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH04-17 Issue d. 11/18/18 FAA-STD SR019371

Plex 12/17/18 8:16 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
120	QC 4	2 pcs	1/7/19	0.00 0.00	QC 4 - 26	
					QC 4 - 28	
					QC 4 - 38	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
130	Packaging 3-1 - Stock - B4B	2 pcs	1/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
135	DC - 1 - B4B	2 pcs	1/7/19	0.00 0.00	DC - 1 - B4B	
					DC - 2 - B4B	
140	QC 21 - FG	2 pcs	1/7/19	0.00 0.00	QC 21 - FG - 21	
Part Op 110 - (Pick Kit)						
Descriptions: 120 - (QC4- 100% Inspect kits for completeness)						
130 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D044-715-011						
LOCATION: FG011						
135 - (Document Control) Photocopy bluefile & type labels per PPPD044-715-011 CHG003						
140 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

ALS4-1032-130	Rivnut	8 Ea (4 ea)	110-Packaging 1 - Pick Kit
AN3-4A	Bolt	8 Ea (4 ea)	110-Packaging 1 - Pick Kit
AN526C1032R10	Screw	8 Ea (4 ea)	110-Packaging 1 - Pick Kit
D1048	Clamp	4 pcs (2 ea)	110-Packaging 1 - Pick Kit
D1049	Saddle	4 pcs (2 ea)	110-Packaging 1 - Pick Kit
D2010-104	Arm	2 pcs (1 ea)	110-Packaging 1 - Pick Kit
D2011-101	Mirror 6"	2 Ea (1 ea)	110-Packaging 1 - Pick Kit
D3243-041	Bracket	2 pcs (1 ea)	110-Packaging 1 - Pick Kit
NAS1149D0332J	Washer	8 Ea (4 ea)	110-Packaging 1 - Pick Kit

5006241
 5112901
 5071664
 5105236
 5097627
 5106474
 5123595
 5107738
 5113757

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	ALS4-1032-130	8	10,334	0
	AN3-4A	8	193	0
	AN526C1032R10	8	95	0
	D1048	4	26	0
	D1049	4	8	0
	D2010-104	2	4	0
	D2011-101	2	25	0
	D3243-041	2	6	0
	NAS1149D0332J	8	1,390	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

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Other/Details:					

2. GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D044-715.

3. INSTALLATION INSTRUCTIONS

To install the Dart Cargo Mirror Installation on the R44 skidtube:

1. Locate the D3243-041 Bracket with approximately 0.38" (10mm) space between the top of the skidtube and the bracket, as shown in Figure 2. Transfer drill the 4 holes from the bracket to the centerline of skidtube and enlarge to 10/64" (Ø0.297"). Deburr holes and wet install ALS7-1032-130 inserts using MIL-P-85582 or MIL-P-23377 primer.
2. Install the D3243-041 Bracket on the skidtube using the AN3 hardware. The bolts should be sealed with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing as per Figure 2.
3. Install remaining hardware per Figure 2 as required. Adjust the angle of the D2010-104 Arm and tighten the AN526C1032R10 screws to secure arm.
4. To adjust the mirror: loosen (DO NOT REMOVE) the three adjustment screws shown in Figure 2, reposition the mirror, then tighten the screws.

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-715-011 Cargo Mirror Installation	1.3 lb 0.59 kg	41.7 in 1.06 m	54.2 lb-kG 0.63 m-kG	32.0 in 0.81 m	41.6 in-lb 0.48 m-kG

5. PARTS LIST

Qty	Part Number	Description
X	D044-715-011	CARGO MIRROR INSTALLATION
2	D1048	Clamp
2	D1049	Saddle
1	D2010-104	Arm
1	D2011-101	Mirror
1	*D3014-1	Locknut
1	D3243-041	Bracket
4	ALS7-1032-130	Insert (or AKS7-1032-130, AKS4-1032-130, ALS4-1032-130)
4	AN3-4A	Bolt
4	AN526C1032R10	Screw (or AN526-1032R10)
4	AN960JD10L	Washers
1	*AN960JD416L	Washer

* PARTS ARE INCLUDED WITH D2011-101 MIRROR

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Revision: **A**

Date: 04.01.20

Change Record

Part Number D044-715-011
Description 244 CARGO MIRROR

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